

Date: Monday, 02/02/2009 3:49:01 PM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : D119 HELI UTILITY BASKET
Job Number : 45428	
Estimate Number : 12452	
P.O. Number :	Part Number : D119756041
This Issue : 02/02/2009 S.O. No. :	Drawing Number : IIN PG11-12
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : LARGE FAB ASSY	Drawing Revision : C
Previous Run : 45427	Material :
Written By :	Due Date : 01/04/2009 Qty: 1 Um: Each
Checked & Approved By : <u>JLD 09.02.03</u>	
Comment : Est Rev:A New Issue 06-06-14 JLM	
Est Rev. B 06.07.26 dwg revB, picklist EC	
est rev C revC dwg 07.04.09 EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	DC	DOCUMENT CONTROL
-----	----	------------------



for JLD 09/03/16



Comment: Photocopy bluefile & type labels per PPPD119-756-041 CHG 002 *S 09/04/29*

2.0	45428A	BASKET LID ASS'Y (A119)
-----	--------	-------------------------



Comment: Sub-Component BASKET LID ASS'Y (A119) SUB-COMPONENT
 1 x D3515-041 Batch: 45428A

BK/Fd

09/04/29

3.0	45428B	BASKET BASE ASS'Y (A119)
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Comment: Sub-Component BASKET BASE ASS'Y (A119) SUB-COMPONENT
 1 x D3516-041 Batch: 45428A

BK/Fd

09/04/29

4.0	D2022101	Spacer
-----	----------	--------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Spacer

Batch: 41928

9/4/24

SP

5.0	D2258220	Placard
-----	----------	---------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Placard

Batch: B30810

9/4/24

SP

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Drawing Name: D119 HELI UTILITY BASKET

Job Number: 45428

Part Number: D119756041

Job Number:



Seq. #:	Machine Or Operation:	Description :
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6.0	D2332041	Lid Prop Assembly 6.69" long
-----	----------	------------------------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Lid Prop Assembly 6.69"
Batch: 45682

9/4/24

SP

7.0	D2530	Handle Weldment
-----	-------	-----------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Handle Weldment
Batch: B46579

9/4/24

SP

8.0	D2535	Spring
-----	-------	--------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Spring
Batch: B45389

9/4/24

SP

9.0	D2537	Bushing
-----	-------	---------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Bushing
Batch: B45662

9/4/24

SP

10.0	D2931	Bumper
------	-------	--------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Bumper
Batch: B21139

9/4/24

SP

11.0	D35191	Placard
------	--------	---------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
placard

B37642

9/4/24

SP

12.0	AN316A	Bolt
------	--------	------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Bolt
Batch: 109798

9/4/24

SP

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Drawing Name: D119 HELI UTILITY BASKET

Job Number: 45428

Part Number: D119756041

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

AN47A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Bolt

Batch:

M108928

9/4/24

SP

14.0

AN422A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Bolt

Batch:

M107715

9/4/24

SP

15.0

AN424A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Bolt

Batch:

M108255

9/4/24

SP

16.0

AN517A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

Bolt

Batch:

M110625

9/4/24

SP

17.0

AN960JD416

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Washer

Batch:

M110363

9/4/24

SP

18.0

AN960JD416L

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Washer

Batch:

M110453

9/4/24

SP

19.0

AN960JD516

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

Washer

Batch:

M110523

9/4/24

SP

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

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Job Number: 45428

Part Number: D119756041

Job Number:



Seq. #:	Machine Or Operation:	Description :
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20.0	AN960JD8	Washer
------	----------	--------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Washer
Batch: M110382

9/14/24

SP

21.0	AN9704	Washer
------	--------	--------



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)
Washer
Batch: M110704

9/14/24

SP

22.0	MS20600AD4W3	Cherry Rivets
------	--------------	---------------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Cherry Rivets
Batch: M104715

9/14/24

SP

23.0	MS21042L3	Nut
------	-----------	-----



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Nut
Batch: M110844

9/14/24

SP

24.0	MS21042L4	Nut
------	-----------	-----



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)
Nut
Batch: M110450

9/14/24

SP

25.0	MS21042L5	Nut
------	-----------	-----



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)
Nut
Batch: M109840

9/14/24

SP

26.0	D37571	Blanking Plate
------	--------	----------------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Blanking Plate
batch: 1538715

9/14/24

SP

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Customer: CU-DAR001 Dart Helicopters Services

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Job Number: 45428

Part Number: D119756041

Job Number:



Seq. #:

Machine Or Operation:

Description :

27.0

AN311A - AN310A

Bolt

AN3-11A
09.04.29



09.04.29



Comment: Qty.: 6.0000 Each(s)/Unit Total: 6.0000 Each(s)

Bolt M169927

batch ~~M1409921~~

~~M17566~~

9/4/24

SP

28.0

AN960JD10

Washer



Comment: Qty.: 12.0000 Each(s)/Unit Total: 12.0000 Each(s)

Washer

batch M110985

9/4/24

SP

29.0

MS21042L3

Nut



Comment: Qty.: 6.0000 Each(s)/Unit Total: 6.0000 Each(s)

Nut

batch M110844

9/4/24

SP

30.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1
Assemble as per Dwg D119-756

FD 1/6/24 09/04/29

31.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

8 02/04/29

32.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
Pick Packing Kit

33.0

D119756011

Clamp



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

CLAMP KIT

Batch: B45679

9/4/24

SP

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Job Number: 45428

Part Number: D119756041

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

34.0	D26173	Bushing
------	--------	---------



B46606

9/4/29



SP

Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Bushing

35.0	D26175	Spacer
------	--------	--------



B46607

9/4/29



SP

Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)
Spacer

36.0	D351611	Clevis
------	---------	--------



9/4/29



SP

Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
CLEVIS
batch: B45714

37.0	D35171	Strut
------	--------	-------



9/4/29



SP

Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
STRUT
Batch: B46280

38.0	D3518041	Strut Assembly
------	----------	----------------



9/4/29



SP

Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
FWD ARM ASSEMBLY
Batch: B46201

39.0	D35201	Spacer
------	--------	--------



B45568

9/4/29



SP

Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
SPACER

40.0	AN413A	Bolt
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14

Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Bolt
Batch: M116731

9/4/29

SP

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Job Number: 45428

Part Number: D119756041

Job Number:



Seq. #:	Machine Or Operation:	Description :
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41.0	AN415A	Bolt
------	--------	------



9/4/24



Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s)
Bolt
Batch: M110399

SP

42.0	AN420A	Bolt
------	--------	------



9/4/24



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Bolt
batch: M16895

SP

43.0	AN510A	Bolt
------	--------	------



9/4/24



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Bolt
batch: M110367

SP

44.0	AN960JD416	Washer
------	------------	--------



9/4/24



Comment: Qty.: 40.0000 Each(s)/Unit Total : 40.0000 Each(s)
Washer
Batch: M110367

SP

45.0	AN960JD416L	Washer
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M110153
M110453

9/4/24



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)
Washer

SP

46.0	AN960JD516L	Washer
------	-------------	--------



M14411

9/4/24



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Washer

SP

47.0	MS21042L4	Nut
------	-----------	-----



Comment: Qty.: 10.0000 Each(s)/Unit Total : 10.0000 Each(s)
Nut
Batch: M110450

Q

SP

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: D119 HELI UTILITY BASKET

Job Number: 45428

Part Number: D119756041

Job Number:



Seq. #:

Machine Or Operation:

Description :

48.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

8086469 @

49.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D119

Location: _____

PPP Rev: _____

Rev C

SS 09/04/29 (X)

50.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/04/30

Job Completion



MF
09-04-30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

4.0 REPLACEMENT PARTS

Figures 4 and 5 list components of the Dart *Heli-Utility-Basket™* which can be replaced if required. Their part numbers are included for reference only, and are normally included with the D3515-041 Basket Lid Assembly or the D3516-041 Basket Base Assembly.

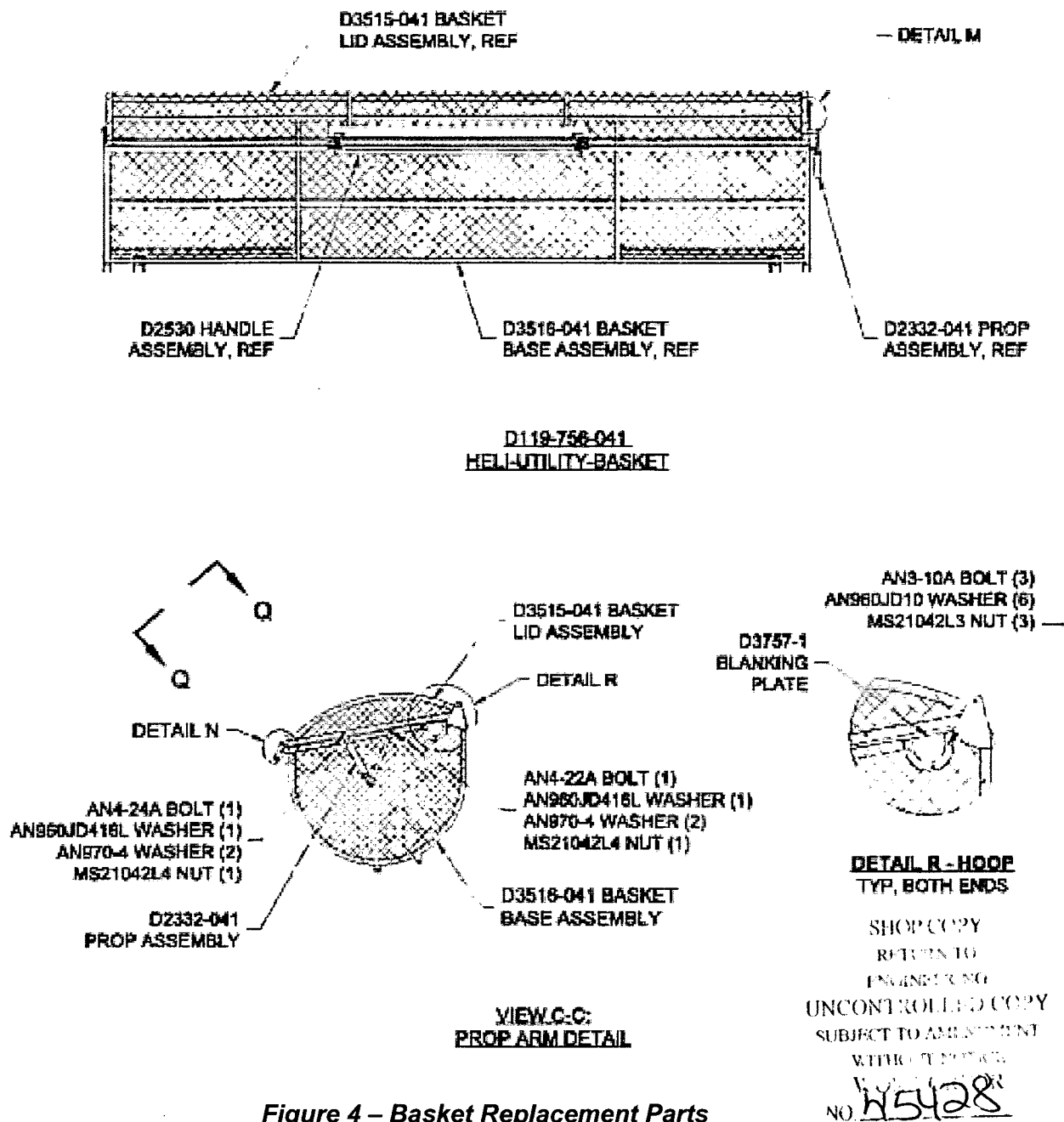
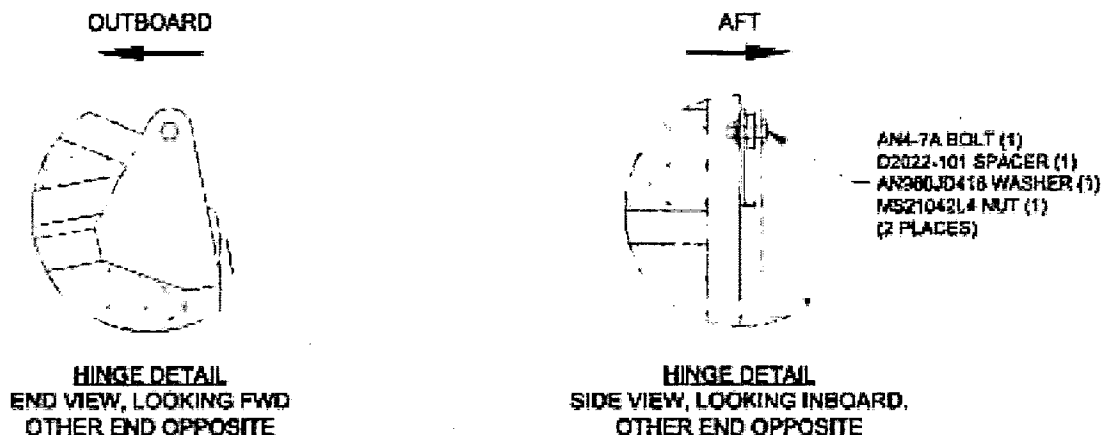


Figure 4 – Basket Replacement Parts
(D119-756-041 Heli-Utility-Basket™)

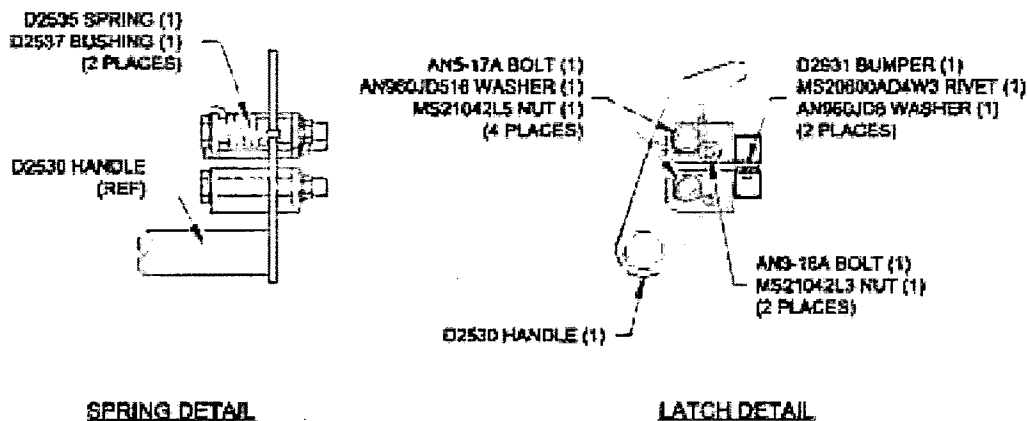
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Revision: **D**

Date: 08.05.07



DETAIL M: HINGE



DETAIL N: HANDLE WELDMENT

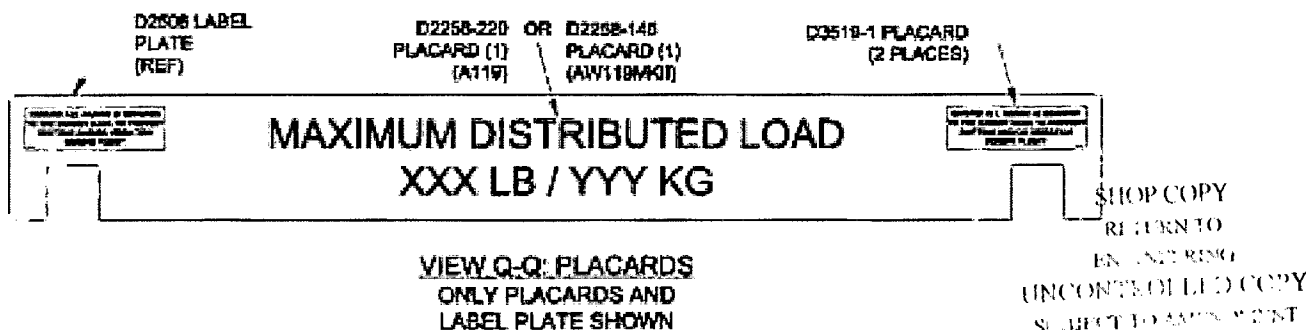


Figure 5 – Basket Replacement Parts & Placards
(D119-756-041 Heli-Utility-Basket™)

5.0 WEIGHT AND BALANCE

There is a negligible weight change associated with the installation of the **D119-756-013 Quick Release Kit**. The following is the weight and balance information for the **D119-756-041 Heli-Utility-Basket™** and the **D119-756-011 Clamp Kit**.

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D119-756-041 Heli-Utility-Basket™ , LH or RH on A119	118.0 lb 53.6 kg	± 46.0 in ± 1.17 m	± 5428.0 lb-in ± 62.7 kg-m	120.0 in 3.05 m	14160 lb-in 163.5 kg-m
D119-756-011 Clamp Kit , LH or RH on A119	0.8 lb 0.36 kg	± 24.5 in ± 0.62 m	± 19.6 lb-in ± 0.22 kg-m	120.0 in 3.05 m	96.0 lb-in 1.1 kg-m
D119-756-041 Heli-Utility-Basket™ , RH only on AW119MKII	118.0 lb 53.6 kg	+ 48.0 in + 1.22 m	+ 5664.0 lb-in + 65.4 kg-m	120.0 in 3.05 m	14160 lb-in 163.5 kg-m
D119-756-011 Clamp Kit , RH only on AW119MKII	0.8 lb 0.36 kg	+ 26.5 in + 0.67 m	+ 21.2 lb-in + 0.24 kg-m	120.0 in 3.05 m	96 lb-in 1.1 kg-m

6.0 POSSIBLE QUICK RELEASE PIN REPLACEMENT

Bolt	Minimum Grip	Replacement Pin P/N
AN4-15A	1.20" (30.5mm)	AVIBANK: BLC4B12S, BLC4TA12S, BLC4R12S, BLC4LA12S MS NUMBER: MS17984C412, MS17985C412, MS17986C412, MS17987C412 REID TOOLS: BLRS-020

NOTE: The qty(2) AN4-15A bolts that secure the D3517-1 Struts mounted on the Basket Base to the D3516-11 Clevises and the qty(2) AN4-15A bolts that secure the top of the Basket Base to the D3518-041 Strut Assemblies may be replaced with stainless steel positive locking quick release pins with a minimum double shear strength of 2400 lbs and 0.25" diameter (10700N and 6.4mm diameter). The **Dart D119-756-013 Quick Release Kit** can be procured from Dart to provide the necessary quick release hardware.

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WITHOUT NOTICE
NO 45428

7.0 PARTS LIST

Qty -041	Qty -011	Qty -013	Part Number	Description
X			D119-756-041	HELI-UTILITY-BASKET™
1	X		D119-756-011	CLAMP KIT
		X	D119-756-013	QUICK RELEASE KIT
2			D2022-101	* SPACER
1			D2258-220	PLACARD (A119)
1			D2258-146	PLACARD (AW119MKII)
1			D2332-041	* PROP ASSEMBLY
1			D2530	* HANDLE ASSEMBLY
2			D2535	* SPRING
2			D2537	* BUSHING
2	2		D2617-3	BUSHING
4	4		D2617-5	BUSHING
	4		D2732-032	RUBBER CUSHION
2			D2931	* BUMPER
	1		D3041-1	CLAMP (A119)
	1		D3041-3	CLAMP (A119)
	1		D3041-5	CLAMP (A119)
	1		D3041-7	CLAMP (A119)
	1		D3789-1	CLAMP (AW119MKII)
	1		D3789-3	CLAMP (AW119MKII)
	1		D3789-5	CLAMP (AW119MKII)
	1		D3789-7	CLAMP (AW119MKII)
1			D3515-041	* BASKET LID ASSEMBLY
1			D3516-041	* BASKET BASE ASSEMBLY
2			D3516-11	CLEVIS
2			D3517-1	STRUT
2			D3518-041	STRUT ASSEMBLY
2			D3519-1	* PLACARD
2			D3520-1	SPACER
2			D3757-1	* BLANKING PLATE

* indicates that part is pre-assembled on basket for customer

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NO 105428

Qty -041	Qty -011	Qty -013	Part Number	Description
6			AN3-10A	* BOLT
2			AN3-16A	* BOLT
2			AN4-7A	* BOLT
2			AN4-13A	BOLT
6			AN4-15A	BOLT
	2		AN4-17A	BOLT
2	2		AN4-20A	BOLT
1	2		AN4-22A	* BOLT
1	2		AN4-24A	* BOLT
2			AN5-10A	BOLT
4			AN5-17A	* BOLT
2			AN960JD416	* WASHER
40	4		AN960JD416	WASHER
2			AN960JD416L	* WASHER
4			AN960JD416L	WASHER
4			AN960JD516	* WASHER
2			AN960JD516L	WASHER
2			AN960JD8	* WASHER
12			AN960JD10	* WASHER
4			AN970-4	* WASHER
		4	BLRS-020	POSITIVE LOCKING QUICK RELEASE PIN
2			MS20600AD4W3	* RIVET
8			MS21042L3	* NUT (OR MS21042-3)
4			MS21042L4	* NUT (OR MS21042-4)
10	4		MS21042L4	NUT (OR MS21042-4)
4			MS21042L5	* NUT (OR MS21042-5)

* indicates that part is pre-assembled on basket for customer

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UNCLASSIFIED

45428